

Work Order ID 50500

July 10, 2009 2:50:17 PM



Page 1

Item ID: D3963-1KIV

Accept



Setup Start



Revision ID: A-PROTO

Stop



Item Name: Light Cover

Start Date: 07/13/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 07/17/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: mf

Date: 09-07-10 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D3963	A-PROTO 09.06.22								

100 0.00



Hand Thermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

BB 09/07/15 (X) M109703

110

0.00



Thermoform

Memo

0.00

Thermoforming Machine

1-Machine Set-Up
2-Pre-heat Tool to required temp.
3-Thermoform as per Dwg and Folio #FTA063 using tool DT9xxx
Dwg Rev: A
Folio Rev: A

BB 09/07/15 (X)

Work Order ID 50500



Page 2

July 10, 2009 2:50:17 PM

Item ID: D3963-1KIV

Accept



Setup Start



Revision ID: A-PROTO

Stop



Item Name: Light Cover

Start Date: 07/13/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 07/17/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

Visually inspect part for proper formation and texture

BB 09/07/15 x1

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

BB 09/07/16 (X1)

140

0.00



Hand Thermo

Memo

0.00

Hand Finishing Thermoforming

1-Trim to finished dimensions as per Dwg

BB 09/07/15 (X1)

Work Order ID 50500



Page 3

July 10, 2009 2:50:17 PM

Item ID: D3963-1KIV

Accept



Setup Start



Revision ID: A-PROTO

Stop



Item Name: Light Cover

Start Date: 07/13/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 07/17/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo Complete FAI document	0.00 0.00							
160 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
170 Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00							

0.00

0.00

0.00

0.00

0.00

09/07/18 XI
ENGINEERING
APPROVAL
RH 09-07-20
24-07-09
FOR
ENG'G TEST
09-07-20

Work Order ID 50500

July 10, 2009 2:50:17 PM

Page 4

Item ID: D3963-1KIV

Accept

Setup Start

Revision ID: A-PROTO

Stop

Item Name: Light Cover

Start Date: 07/13/2009 Start Qty: 1.00

Required Date: 07/17/2009 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

A .09.07.20 Prototype

QC

Memo

0.00

Quality Control

Picklist Print

Page 1

July 10, 2009 2:50:17 PM

Work Order ID: 50500

Parent Item: D3963-1KIVRevA-PROTO

Parent Item Name: Light Cover

Comments:

Start Date: 07/13/2009

Required Date: 07/17/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MKYD6185S.080-P3- 62015		Purchased	No			100	sf	894.5038	0.5938			



6185 KYDEX .080"



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

894.5037653

109703

894.503765

BB

M109703

27 X 21 1/5

W/O 50491

501

502

503

DART AEROSPACE LTD		Work Order: 50500
Description: <u>Light Cover</u>		Part Number: <u>D3963-1K1V</u>
Inspection Dwg: <u>A</u>	Rev: <u>A</u>	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____"	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: BB

Date: 09/07/16

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.25	$\pm .005$ @ .10	.2695	✓			
3.9	Ref	3.9	✓			
4.9	Ref.	4.9	✓			
2.0		2.06	✓			
.0830	min	0.085, 0.067	✓			
0.44	± 0.03	0.43	✓			NOT REQ'D <u>PH</u> 09.07.20
0.50	↓	0.52	✓			
0.38		0.37	✓			
0.75	↓	0.76	✓			
φ0.125	± 0.005 ± 0.001	φ0.126	✓			

Measured by: BB

Date: 09/07/16

Audited by: PH

Date: 09.02.12

Prototype Approval: PH

Date: 09.07.17

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	

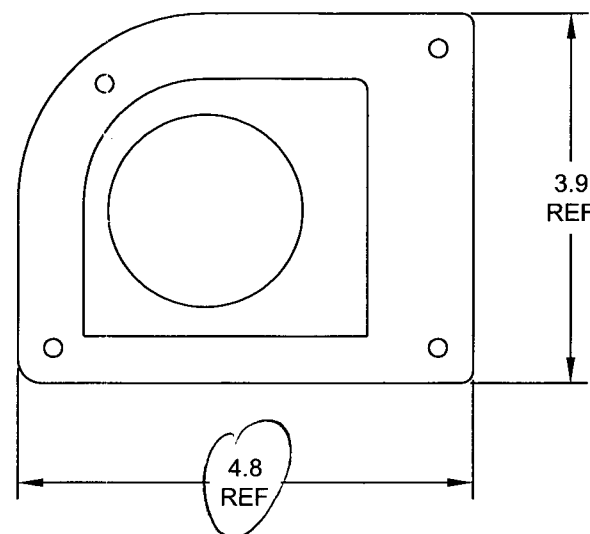
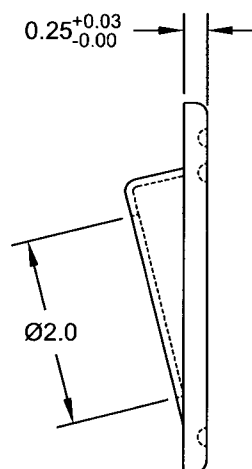
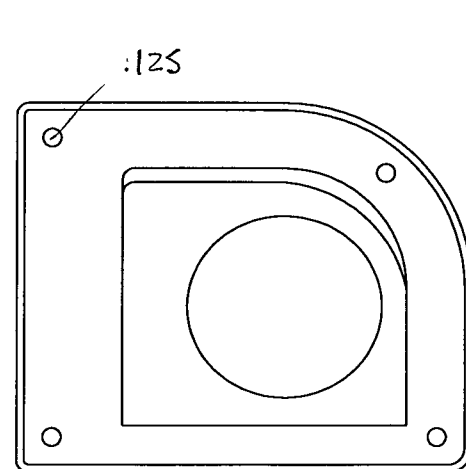
8 7 6 5 4 3 2 1

D

C

B

A



4.9

D3963-1 LIGHT COVER

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
09.07.07 PH

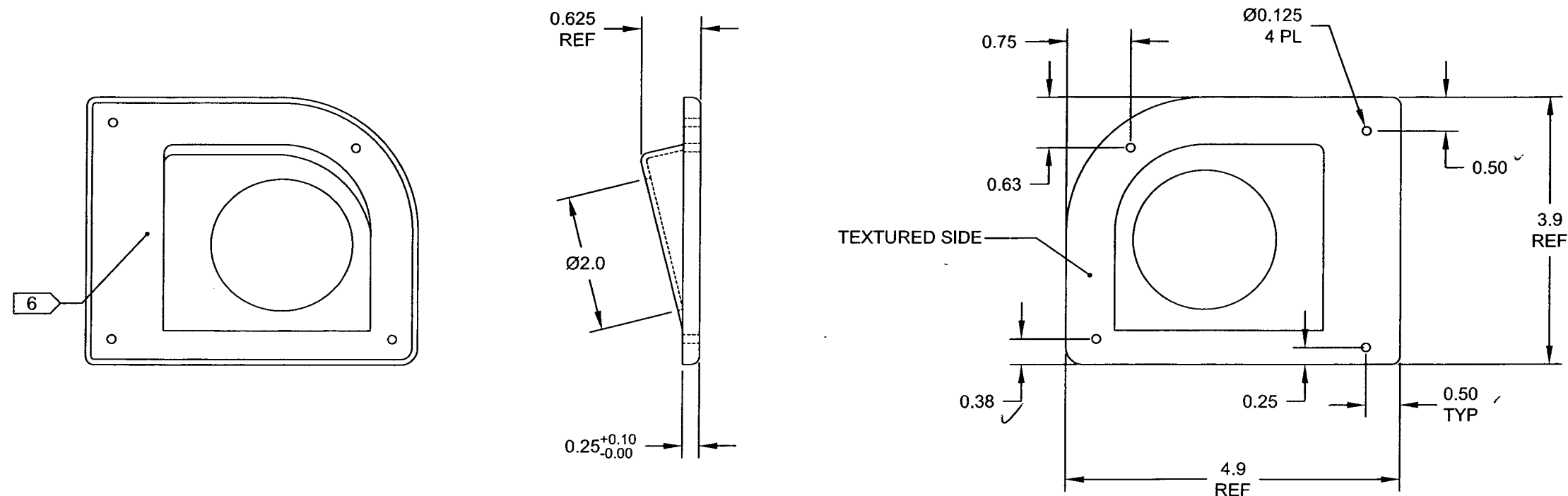
NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 0.05 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9072 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" UNLESS OTHERWISE NOTED

PART NUMBER	DESCRIPTION
D3963-1KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3963-1KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

A	NEW ISSUE	PH	09.06.22
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3963	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		LIGHT COVER (206 L3/L4)	NTS
DATE	09.06.22	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1



D3963-1 LIGHT COVER

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 0.05 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9355 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.030" UNLESS OTHERWISE NOTED

PART NUMBER	DESCRIPTION
D3963-1KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3963-1KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

A	NEW ISSUE	PH	09.06.22
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3963	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		LIGHT COVER (206 L3/L4)	NTS
DATE	09.06.22	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	